

Work Order ID 79528

January-26-12 4:14:32 PM

SHIP
FEB 10

79528

Page 1

Item ID: D2806-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bushing
 Start Date: 26/01/2012 Start Qty: 24.00 *24* Cust Item ID:
 Required Date: 10/02/2012 Req'd Qty: 24.00 *24* Customer:
 Reference:

Approvals: Process Plan: M.L.J. Date: 12/01/27 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2806	Rev A								

100 DOOSAN LATHE 0.00
 100
 Doosan Memo 0.00
 Doosan Lathe 1- Turn as per Folio FA105 Rev: AA & Dwg D2806 Rev: A 2-Deburr
 per dwg D2806 OK 12/02/02 25 φ

110 QC2- Inspect parts off machine FAI/FAIB 0.00
 110
 QC Memo 0.00
 Quality Control OK 12/02/02 25 φ

120 QC8- Inspect parts - second check 0.00
 120
 QC Memo 0.00
 Quality Control B.A 12/02/02 25 φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: <u>018</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									

25 BLK 12-23

25 4 all in stock
 counted

14/4 (20)

W/O:		WORK ORDER CHANGES					
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Required Date: 10/02/2012 Req'd Qty: 24.00 ***24*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ 12/02/06

12026
25

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 79528

79528

Parent Item: D2806-3

D2806-3

Parent Item Name: Bushing

Start Date: 26/01/2012

Required Date: 10/02/2012

Start Qty: 24.00

Required Qty: 24.00

Comments:

IPP: B05.03.11Part now turned KJ/JLM

IPP Rev:C Now on Doosan Lathe JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6H1.000

Purchased

No

110

f

11.7880

0.0916

2.314105

M6061T6H1 000

6061-T6 HexBar 1.00

Location

Loc Qty

Loc Code

MAT012

11.788

109478

0.421

116623

0.897

→ 119275

10.47

2.4

OK 12/02/02

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DART AEROSPACE LTD		Work Order:	79528
Description: Bushing		Part Number:	D2806-3
Inspection Dwg: D2806 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/-0.010	1.007	—		Vern 71-06	
1.155	+/-0.010	1.150	—		"	
0.250	+/-0.010	.248	—		"	
0.063 x 45°	+/-0.010	.063x45°	—		"	
0.080 x 45°	+/-0.010	.073x45°	—		"	
0.495	+0.000/-0.005	.492	—		"	
0.750	+0.000/-0.005	.747	—		"	
Ø0.316	+0.005/-0.000	Ø.317	—		"	
0.094	+/-0.005				"	

Measured by: <i>arf</i>	Audited by: <i>h.a</i>	Prototype Approval:	N/A
Date: 12/02/02	Date: 12/02/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF	
B	08.11.27	0.094 dimension added	KJ/EC <i>af</i>	<i>h</i>

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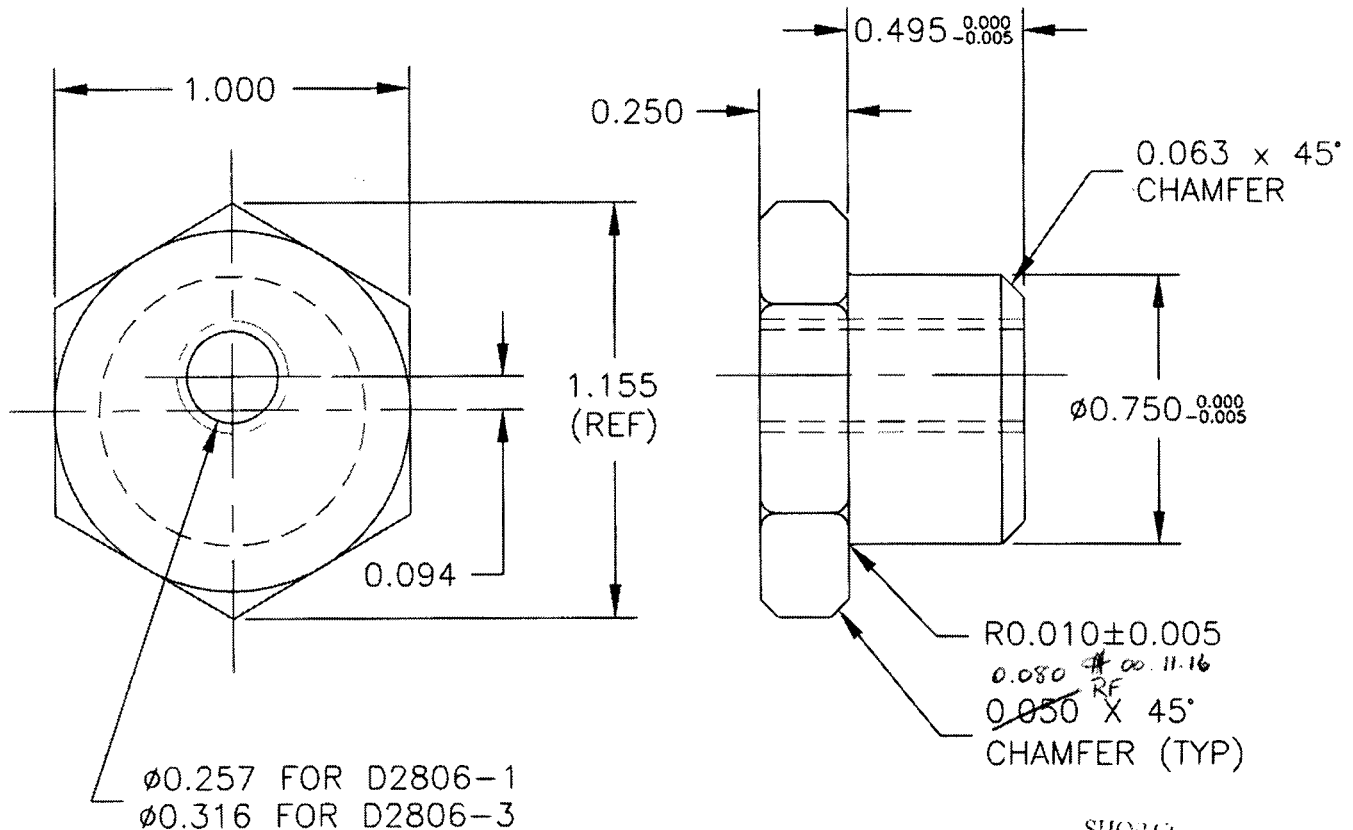
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2806	REV. A SHEET 1 OF 1
DATE 00.11.08		TITLE BUSHING SCALE 2:1	
A	00.11.08	NEW ISSUE	

RELEASED
00.11.13 *[Signature]*



D2806-1 (DRILL $\phi 0.257$ HOLE)
D2806-3 (DRILL $\phi 0.316$ HOLE)

SHOWN
REVISION
ENGINEER
UNCONTROLLED
SUBJECT TO
WRITE
WORK
NO. 79528 H.C.S.
12/01/27

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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